



## SYSTEM INFORMATION

### Blending in on the adjacent panel with Glasurit 90 Line tri-coat colors (translucent step 2)

#### Mazda 41V

The three service mixing formulas are recommended to be used in conjunction with this blending process.

With all translucent colors there is the need to verify the amounts of spray coats needed for each color match for each vehicle. Therefore, and due to differences in application techniques we recommend to apply different amounts of spray coats of Step 2 (translucent coat) to test panels of Step 1 to match the process and color of the vehicle to be repaired.

This process provides paint material and time saving advantages:

- Fewer coats of Step 2 are needed
- Easier and safer blending process
- No need to use Glasurit Blending Clear 90-M50

Service Formula 1		Service Formula 2		Service Formula 3	
Mazda 41V	Step 1	Mazda 41V	Step 1	Mazda 41V	Step 1
90-M4	68,28	90-M4	67,31	90-M4	66,89
90-M99/03	9,70	98-M319	11,85	90-M99/03	8,14
98-M319	5,34	90-M99/03	3,09	98-M319	5,71
90-A347	14,14	90-A347	15,05	90-A347	14,25
80-M351K	2,53	80-M351K	2,70	80-M351K	4,48
				90-A927	0,30
Mazda 41V	Step 2	Mazda 41V	Step 2	Mazda 41V	Step 2
90-M4	12,26	90-M4	12,26	90-M4	12,26
90-M5	79,94	90-M5	79,94	90-M5	79,94
98-M319	1,26	98-M319	1,26	98-M319	1,26
11-E910	0,10	11-E910	0,10	11-E910	0,10
90-3A0	3,46	90-3A0	3,46	90-3A0	3,46
90-A350	2,99	90-A350	2,99	90-A350	2,99

**Remark:** In all 3 cases, the Step 2 mixing formula remains the same.

Service formula 1 is lighter in color than Service formula 2.

Service formula 3 is bluer and was formulated to plastic parts e.g. bumpers.

#### Recommendation:

Service formula 1 and Service formula 3 usually need 2½ coats of Step 2; Service formula 2 requires based on our experiences 1½ coats of Step 2. Please check color and application first on test panels before applying to the vehicle.

#### Please refer to the following Blending Process:

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## SYSTEM INFORMATION

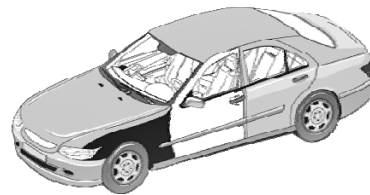
### Blending in on the adjacent panel with Glasurit 90 Line tri-coat colors (translucent step 2) Mazda 41V

**Properties:** In principle, panel repairs with translucent 90 Line tri-coat colors are possible. Therefore, it is in general not necessary to respray adjacent body parts. But when color differences beyond allowable limits are to be expected, the more appropriate method to balance color differences may be to blend into the damaged area and/or the adjacent panel, depending on the damage. This procedure can be considerably more efficient and economical than time-consuming color matching.

- Remarks:**
- Stick to the recommended flash-off times.
  - Flash off after each spray coat until the surface is completely mat.
  - Flash-off times can be reduced by additional ventilation with blow equipment (e.g. Dry Jet).
  - Brief increase of temperature in combined spray booths or by intermediate drying at 40°C in the oven after the final coat.
  - An increasing basecoat thickness needs more flash-off time.

#### 1. Pre-treatment of the adjacent panel

700-10 Glasurit® Degreasing and cleansing agent	 1x	 Wipe dry	 Foam pad P1000-P1200
700-1 Glasurit® Cleaner	 1x	 Wipe dry	



Mask the adjacent blending panel.

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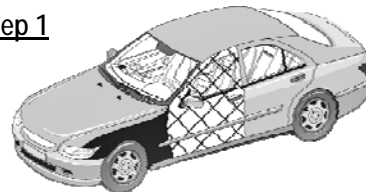


# SYSTEM INFORMATION

## Blending in on the adjacent panel with Glasurit 90 Line tri-coat colors (translucent step 2) Mazda 41V

### 2. Refinishing of the new panel / the panel to be repaired Step 1

90 Line Glasurit® Basecoat Step 1 Mazda 41V	 2:1 93-E3	 HVLP 1.3 mm 2.0 bar	 2 (spray to cover) + ½ coat to match the effect.
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#### Notes:

Viscosity 20 – 21 sec DIN4 / 23°C

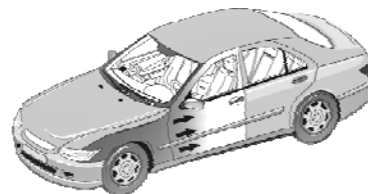
Demask the adjacent panel, after the last spray coat has dried.

Using Step 1 fade out and overlap each spray coat into the adjacent panel.

Keep the blend small and keep the edge transition soft and gradual.

### 2.1 Refinishing of the Blend transition area into the adjacent panel Step 1

90 Line Glasurit® Basecoat Step 1 Mazda 41V	 2:1 93-E3	 HVLP 1.3 mm 1.0-1.5 bar	 1 – 2 fading out on both panels	 ½ coat to match the effect	 flash off until mat
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#### Note:

Reduce spray gun pressure when blending.

After Step 1 has dried, use tack rack on the blended panel to remove any loose over spray.

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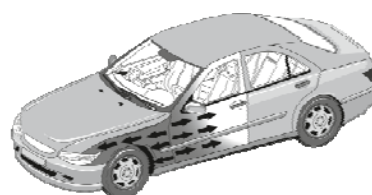


## SYSTEM INFORMATION

### Blending in on the adjacent panel with Glasurit 90 Line tri-coat colors (translucent step 2) Mazda 41V

#### 3. Refinishing of the new panel / the panel to be repaired and of the adjacent panel Step 2

90 Line Glasurit® Basecoat Step 2 Mazda 41 V	 2:1 93-E3	 HVLP 1.3 mm 2.0 bar	2.0 bar on repaired panel. 1.5 bar on blending area	 1-2 + ½ to match the effect	 flash off until mat
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#### Note:

Fade out and overlap each spray coat into the adjacent panel.  
Reduce pressure when blending into adjacent panel if needed,  
Standard spray pressure when applying on the complete panel.

#### 4. Clearcoat application

923- Glasurit® HS VOC Clearcoat	 Refer to the Technical Data Sheet	 HVLP 1.3 mm 2.0 bar	 2	 30 min. at 60°C
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#### Safety advice:

The products are suitable for professional use only.  
It cannot be ruled out that these products contain particles < 0.1 µm.

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